

Work Order ID 77606

77606

Page 1

December-13-11 3:35:30 PM

Item ID: D2893-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: 2.75 Support

Start Date: 13/12/2011 Start Qty: 20.00

Cust Item ID:

Required Date: 23/01/2012 Req'd Qty: 20.00

Customer:

Reference:

Run Start *NR1*

Approvals:

Process Plan: M.C.J

Date: 11/12/13 Tooling:

Date:

Stop *NR2*

QC:

Date: SPC (Y/N):

Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D2893

C

0.00

100

100

HAAS 1

HAAS CNC vertical machine #1

HAAS CNC VERTICAL MACHINING #1

Memo

1-Machine as per Folio FA081
2-Deburr

0.00

110

110

QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

0.00

120

120

QC

Quality Control

QC8- Inspect parts - second check

Memo

0.00

0.00

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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20

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Required Date: 23/01/2012 Req'd Qty: 20.00

20

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
130									
HandFXtube	Memo	0.00							
Hand Finishing Crosstubes	Per note 8 on page 1 of dwg D2893, Prep inner concave surface of support and apply 3M Scotch-Weld as per dwg. 24h of cure time.								
140	QC3- Inspect Part Finish	0.00							
140									
QC	Memo	0.00							
Quality Control									
170	Identify as per dwg & Stock Location	0.00							
170									
Packaging	Memo	0.00							
Packaging									

12-01-09

12-01-09

12 01 09

12-01-09

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20

Cust Item ID:

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20

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.00

Quality Control

12/1/11

12-01-10
mkt

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID: 77606
Parent Item: D2893-1
Parent Item Name: 2.75 Support

77606
D2893-1

Start Date: 13/12/2011 Required Date: 23/01/2012
Start Qty: 20.00 Required Qty: 20.00

Comments: IPP: C02.11.26Reformat: Added P/OKJ
IPP D 06.04.19 removed alodine EC
IPP Rev:E Added priming as per Rev B 07-04-30 JLM
IPP F 08.03.19 Re-format EC verified by: DD
IPP Rev:G 08-05-15 add QC14 DD verified by:EC
11.08.04 as per dwg rev.C DD verf:EC
IPP Rev:H

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
DSK078		Manufactured	No			100	Each	0.0000	0.5	10.52632			
										**			

DSK078
D2893-1 TURNING DETAIL

Location	Loc Qty	Loc Code
MAT	-10	
MAT060 <i>B 771911</i>	10	<i>10</i> <i>26.10.12</i>

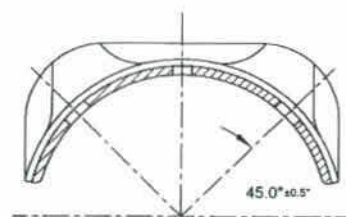
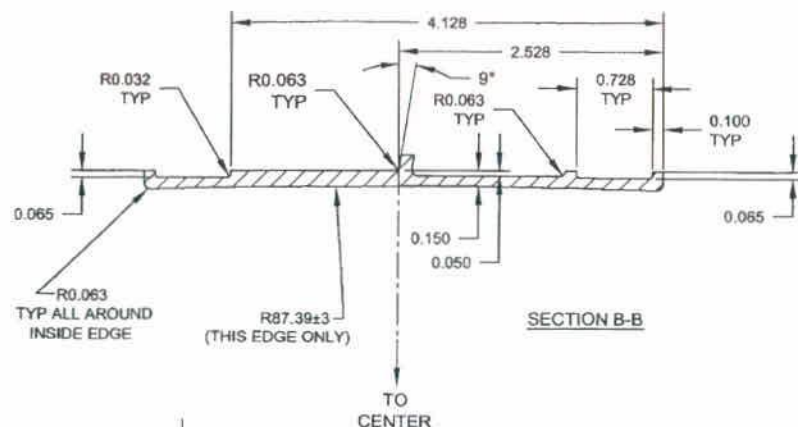
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

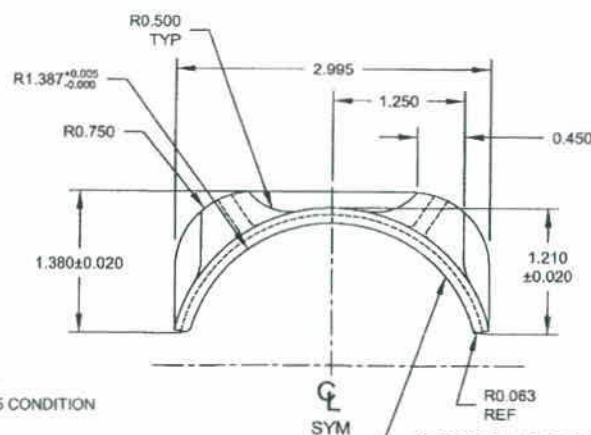
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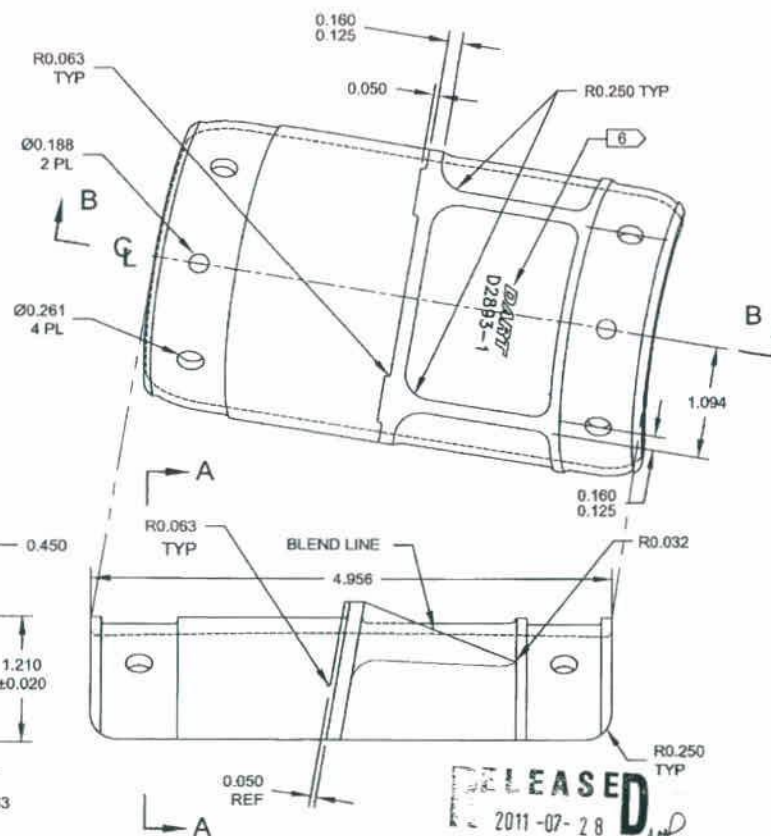
NOTE: Date & initial all entries



SECTION A-A
TOOLING HOLE DETAIL



D2893-1 SUPPORT



NOTES:

- 1) MATERIAL: 17-4 PH STAINLESS STEEL, H900 OR H925 CONDITION
MIN UTS = 170 KSI (38 HRc)
(REF DART SPEC. D6104)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 (REF X.XXX = ±0.010) UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: DART LOGO (PER DART SUPPLIED GRAPHIC) AND PART NUMBER IN THIS AREA WITH 0.125 HIGH LETTERING
0.010-0.020 DEEP, PER DART QSI 044 6.3.
- 7) WEIGHT: 0.78 lb
- 8) FOR THE ENTIRE INNER CONCAVE SURFACE:
ABRADE SURFACE WITH 400-GRIT SANDPAPER. REMOVE RESIDUE WITH MEK (OR EQUIVALENT). APPLY 0.03" TO 0.05" THICK LAYER OF 3M SCOTCH-WELD 2216 B/A EPOXY ADHESIVE TO MATING SURFACE OF SUPPORT. ALLOW TO CURE FOR 24 HOURS.

C	RMV FINISH, ADD 3M 2216, ADD H925 MAT'L OPTION	CP	11.07.15
B	UPDATE DIMS AS MFG, PRIME INSIDE	PH	07.03.16
A	NEW ISSUE	CP	01.01.10
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>JP</i>		
DRAWN	<i>JP</i>		
CHECKED	<i>ASS</i>		
MFG. APPR.	<i>ASS</i>		
APPROVED	<i>ASS</i>		
DE APPR.	<i>ASS</i>		
DATE	11.07.15		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D2893	REV. C SHEET 1 OF 1
TITLE Ø2.750 SUPPORT	SCALE NTS
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77606 M.L.J
11/12/13

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DART AEROSPACE LTD		Work Order: 77606
Description: Ø2.750 Support		Part Number: D2893-1
Inspection Dwg: D2893	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	7 4	5 2	9 3	10 4	11 5
HAAS Section								
AA	2.985	3.005		2.995	2.995	2.995	2.995	2.995
AB	0.440	0.460		0.450	0.450	0.450	0.450	0.450
AC	0.125	0.160		0.130	0.130	0.130	0.130	0.130
AD	0.040	0.060		0.050	0.050	0.050	0.050	0.050
AE	0.188	0.193		0.188	0.188	0.188	0.188	0.188
AF	0.125	0.160		0.140	0.140	0.140	0.140	0.140
AG	0.140	0.160		0.150	0.150	0.150	0.150	0.150
AH	1.360	1.400		1.385	1.385	1.385	1.385	1.385
AI	0.040	0.060		0.055	0.055	0.055	0.055	0.055
AJ	1.190	1.230		1.225	1.225	1.225	1.225	1.225
AK	0.010	0.020		0.010	0.010	0.010	0.010	0.010
AL	0.053	0.073		0.063	0.063	0.063	0.063	0.063
AM	0.240	0.260		0.250	0.250	0.250	0.250	0.250
AN	2.518	2.538		2.525	2.525	2.525	2.525	2.525
AO	84.39	90.39	DT 8699	✓	✓	✓	✓	✓
AP	0.261	0.266		0.261	0.261	0.261	0.261	0.261
AQ	0.053	0.073		0.063	0.063	0.063	0.063	0.063
AR								
AS								
AT								
Accept/Reject								

Measured by: 361	Date: 12/01/07
Audited by: SL	Date: 12-01-08
Prototype Approval:	Date:

Rev	Date	Change	Revised by	Approved
A	02.12.13	New Issue	KJ/RF	
B	07.05.08	Dimension AP revised	KJ/JLM	
C	08.04.21	Reformat	KJ/JLM	

DART AEROSPACE LTD		Work Order: 77606
Description: Ø2.750 Support		Part Number: D2893-1
Inspection Dwg: D2893	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	12 1	13 2	14 3	15 4	16 5
HAAS Section								
AA	2.985	3.005		2.995	2.995	2.995	2.995	2.995
AB	0.440	0.460		.450	.450	.450	.450	.450
AC	0.125	0.160		.130	.130	.130	.130	.130
AD	0.040	0.060		.050	.050	.050	.050	.050
AE	0.188	0.193		.188	.185	.185	.185	.185
AF	0.125	0.160		.120	.120	.120	.120	.120
AG	0.140	0.160		.150	.150	.150	.150	.150
AH	1.360	1.400		1.385	1.385	1.385	1.385	1.385
AI	0.040	0.060		.055	.055	.055	.055	.055
AJ	1.190	1.230		1.225	1.225	1.225	1.225	1.225
AK	0.010	0.020		.010	.010	.010	.010	.010
AL	0.053	0.073		.063	.063	.063	.063	.063
AM	0.240	0.260		.250	.250	.250	.250	.250
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AO	84.39	90.39	DT8699	✓	✓	✓	✓	✓
AP	0.261	0.266		.261	.261	.261	.261	.261
AQ	0.053	0.073		.063	.063	.063	.063	.063
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Measured by: <u>SL</u>	Date: <u>12/01/07</u>
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AG	0.140	0.160		.150	.150	.150	.150	
AH	1.360	1.400		1.385	1.385	1.385	1.385	
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